

Work Order ID 80164

80164

Page 1

February-13-12 10:35:28 AM

Item ID: D3914-7

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Rib

Start Date: 13/02/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 17/02/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: M.L.J

Date: 12/02/13

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D3914 | B | | | | | | | | |

100

0.00

100

Large Fab

Memo

0.00

Large Fab

1- Cut tube as per dwg D3914
2- debur and remove identification markings

OL / PL 12-02-13

4x Ø

110

QC6- Inspect dimensions to drawing

0.00

110

QC

Memo

0.00

Quality Control

5/12/16

4x Ø

120

Identify as per dwg & Stock Location: WA

0.00

120

Packaging

Memo

0.00

Packaging

BASKET CELL

PL 12-02-16

4x Ø

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

80164

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N900040100

Setup Start *NS1*

Stop *NS2*

4

Cust Item ID:

4

Customer:

Reference:

Run Start *NR1*

Stop ***NR2***

**Insp.
Stam**

0.00

130

QC

Memo

0.00

Quality Control

4,12,02.17

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

February-13-12 10:35:31 AM

Page 1

Work Order ID: 80164

80164

Parent Item: D3914-7

D3914-7

Parent Item Name: Rib

Start Date: 13/02/2012

Required Date: 17/02/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B as
per dwg revB DD 10.08.18 verified by:EC IPP Rev:C 11.01.18 chg
qc5 to 6 DD verf:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M304TS0.500W.049 | | Purchased | | | No | 100 | f | 436.0226 | 7.875 | 33.15789 | | | |
| *M304TS0 500W 049* | | | | | | | | | ** | DL | | 12.02.13 | |
| Square Tubing | | | | | | | | | | | | | |

Location

MAT034

116610

117721

117999

118460

Loc Qty

436.0226232

0.8383

0.3234

2.43919739

432.421726

Loc Code

33.15789

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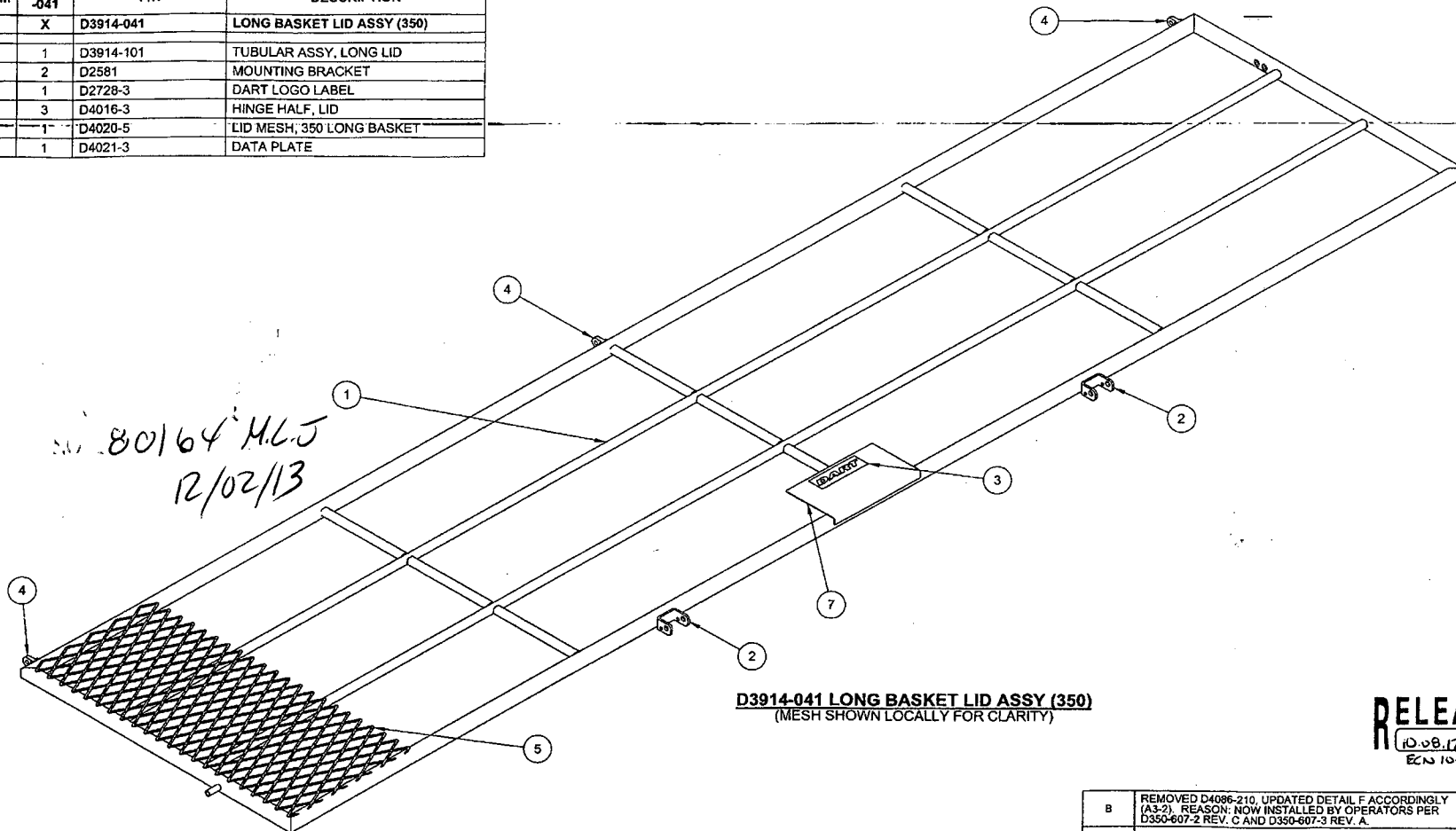
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NOTE: Date & initial all entries

| ITEM | QTY -041 | P/N | DESCRIPTION |
|------|-------------|-----------|----------------------------|
| | X | D3914-041 | LONG BASKET LID ASSY (350) |
| 1 | 1 | D3914-101 | TUBULAR ASSY, LONG LID |
| 2 | 2 | D2581 | MOUNTING BRACKET |
| 3 | 1 | D2728-3 | DART LOGO LABEL |
| 4 | 3 | D4016-3 | HINGE HALF, LID |
| 6 | 1 | D4020-5 | LID MESH, 350 LONG BASKET |
| 7 | 1 | D4021-3 | DATA PLATE |



D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10.08.17
ECN 10-596

| | | | |
|---|---|-----|----------|
| B | REMOVED D4096-210, UPDATED DETAIL F ACCORDINGLY (A3-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A. | MB | 10.08.05 |
| A | NEW ISSUE | JPH | 10.03.16 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | ALS | | |
| DRAWN | SC | | |
| CHECKED | SC | | |
| MFG. APPR. | SC | | |
| APPROVED | SC | | |
| DE APPR. | SC | | |
| DATE | 10.08.05 | | |
| DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3914 TITLE LONG BASKET LID ASSY (350) SCALE NTS REV. B SHEET 1 OF 4 | | | |
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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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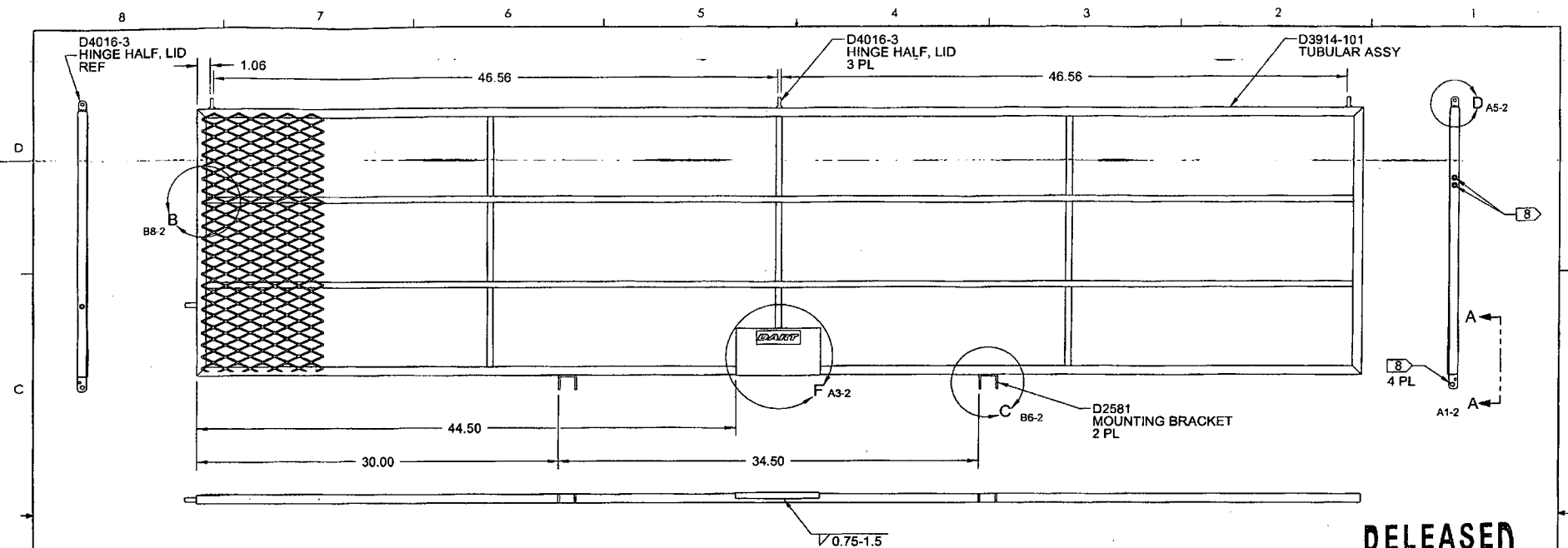
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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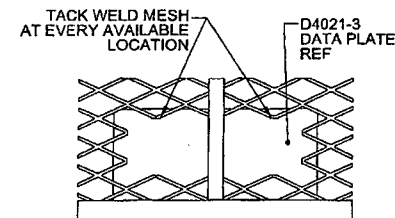
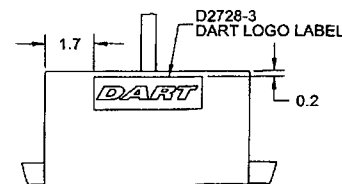
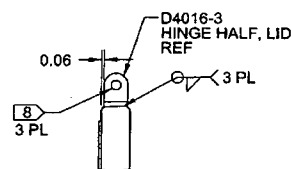
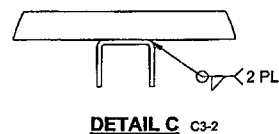
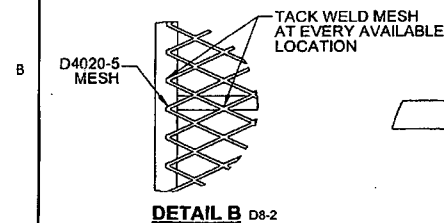
NOTE: Date & initial all entries

80164



D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10.08.12 UP



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.35 lbs APPROX
- 8) MASK HOLES PRIOR TO FINISHING
- 9) WELD PER DART QSI 004

| | | | |
|------------|----------|--|--------------|
| DESIGN | ALS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | SC | DRAWING NO. | REV. B |
| CHECKED | SC | D3914 | SHEET 2 OF 4 |
| MFG. APPR. | MP | TITLE | SCALE |
| APPROVED | MP | LONG BASKET LID ASSY (350) | NTS |
| DE APPR. | MP | COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |
| DATE | 10.08.05 | | |

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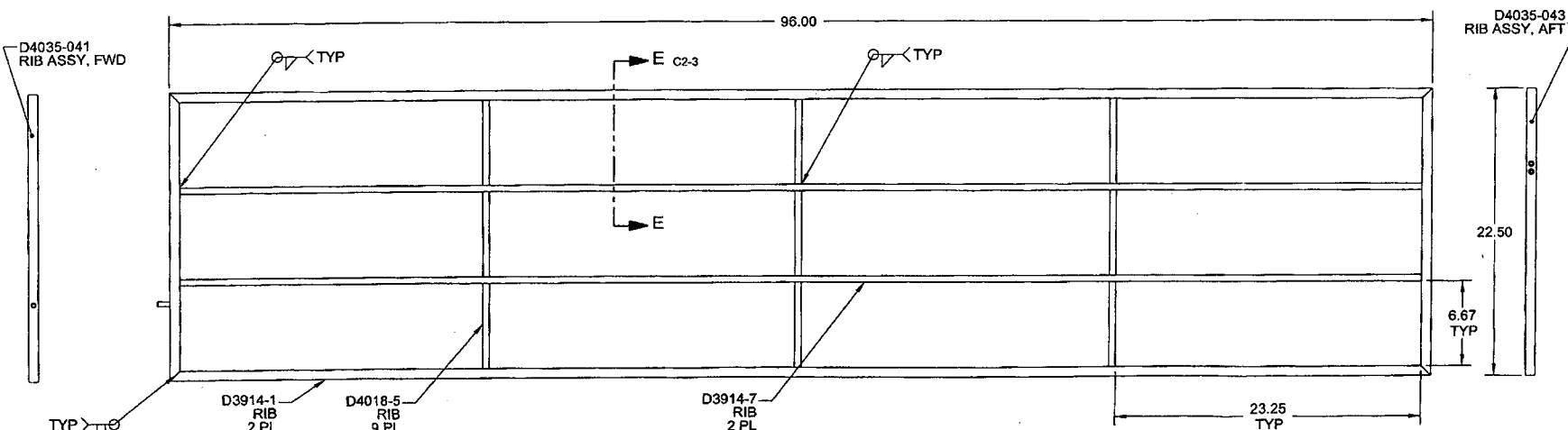
NOTE: Date & initial all entries

80164

| ITEM | QTY -101 | P/N | DESCRIPTION |
|------|-------------|-----------|------------------------------|
| | X | D3914-101 | TUBULAR ASSY, LONG LID (350) |
| 1 | 2 | D3914-1 | RIB |
| 2 | 2 | D3914-7 | RIB |
| 3 | 9 | D4018-5 | RIB |
| 4 | 1 | D4035-041 | BASKET LID RIB ASSY, FWD |
| 5 | 1 | D4035-043 | BASKET LID RIB ASSY, AFT |



SECTION E-E C5-3



8 D3914-101 TUBULAR ASSY, LONG LID

RELEASED
10-08-12

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 14.10 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
- 9) WELD PER DART QSI 004

| | | | |
|------------|----------|--|--------|
| DESIGN | ALS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | PC | DRAWING NO. D3914 | REV. B |
| CHECKED | WJ | SHEET 3 OF 4 | |
| MFG. APPR. | WJ | TITLE | SCALE |
| APPROVED | WJ | LONG BASKET LID ASSY (350) | NTS |
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| DATE | 10.08.05 | | |

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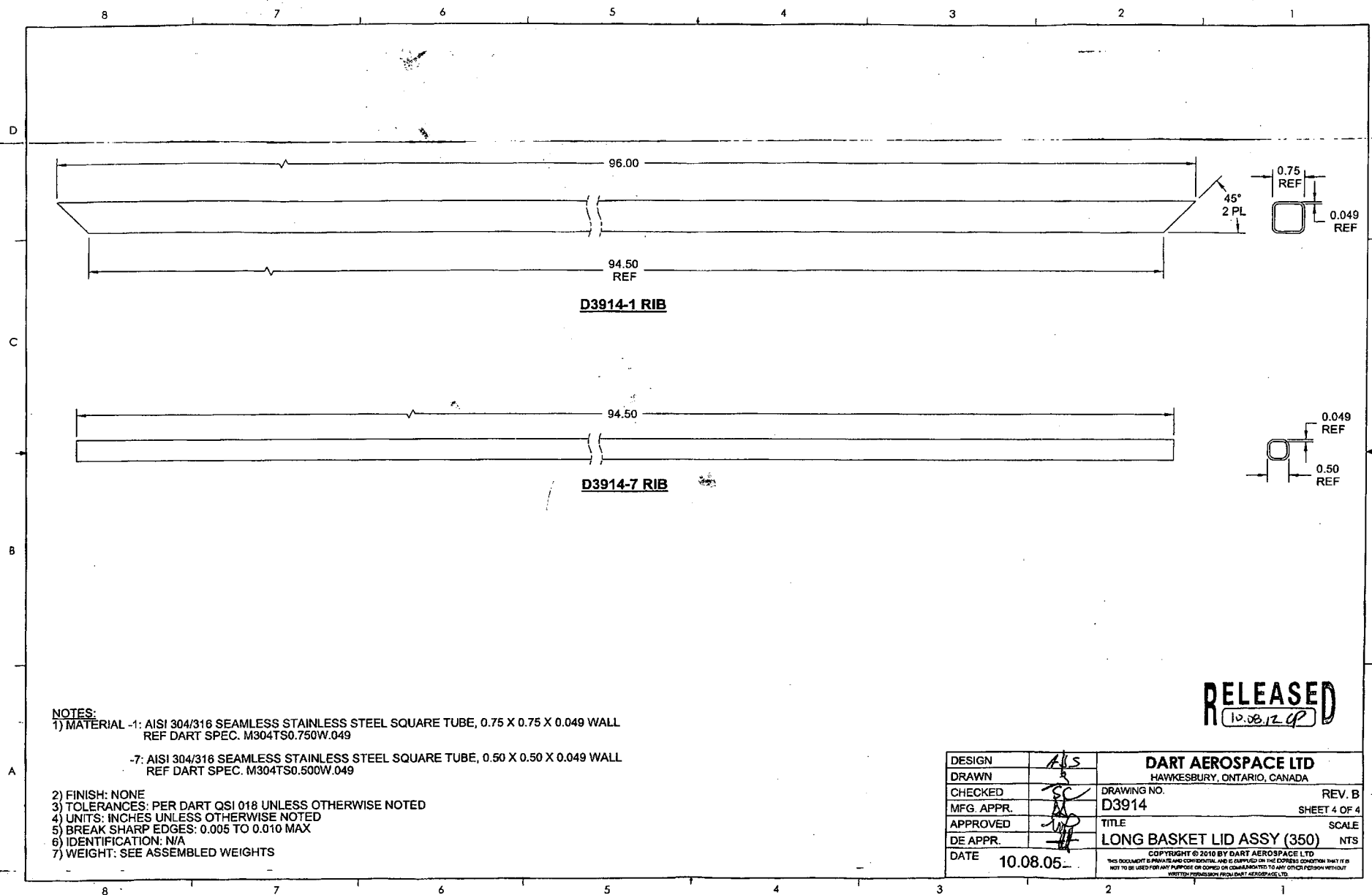
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

80164



RELEASED
10.08.12 GP

NOTES:

1) MATERIAL -1: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049

-7: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

| | | | |
|------------|----------|--|--------------|
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| DRAWN | SC | DRAWING NO. D3914 | REV. B |
| CHECKED | SC | | SHEET 4 OF 4 |
| MFG. APPR. | WJP | TITLE LONG BASKET LID ASSY (350) | SCALE NTS |
| DE APPR. | WJP | | |
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| J: | | WORK ORDER CHANGES | | | | | |
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